



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

647.0112

Job Sheet 174080



Part No: 647.0112

Job Qty: 12 ea

Part Name: Strut Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/9/18

Job Tracking No:

Due Date: 3/23/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG 647.0100 REV.B SHEET 3 IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS IPP REV:B 18.02.08 AS PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	3/22/18	3/22/18	0.00	0.00	Start Up Waterjet		18/03/12
100	Waterjet	12 pcs	3/22/18	3/22/18	0.00	0.47	Waterjet1		18/03/12
110	QC	12 pcs	3/22/18	3/22/18	0.00	0.00	QC2 Waterjet-1		18/03/12
120	QC	12 pcs	3/22/18	3/22/18	0.00	0.00	QC8-1		38
130	Brake NC	12 pcs	3/22/18	3/22/18	0.00	0.54	Brake NC 1		9-89
140	QC	12 pcs	3/22/18	3/22/18	0.00	0.00	QC5		13-3-16
150	SprayPaint	12 pcs	3/23/18	3/23/18	0.00	0.28	Spray Paint		11 MAR 19 2018
160	QC	12 pcs	3/23/18	3/23/18	0.00	0.00	QC14		11 MAR 22 2018
170	Packaging	12 pcs	3/23/18	3/23/18	0.00	0.00	Packaging3-1	CCK/100	21 MAR 23 2018
180	QC21-SA	12 Ea	3/23/18	3/23/18	0.00	0.00	QC21		21 MAR 23 2018

Part Op 100 - 1-Cut as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary
 Descriptions: 130 - USE DT9834 FOR FORMING
 150 - PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N PRIME AS PER DWG NOTE 6 BATCH: 138747
 170 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S14GA	304SS sheet .080	.3900 sf (.0325 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S14GA	0	48	0



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Container No: S050462

Part: 647.0112

Job No: 174080

Serial No/Batch: S050462

Revision: B

Inspector:

Date: 03/12/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut Bracket	0.177Inches + 0.005 - 0.001	0.182 0.176		
2	Strut Bracket	0.191Inches + 0.005 - 0.001	0.196 0.190		
3	Strut Bracket	0.300Inches ± 0.030	0.330 0.270		
4	Strut Bracket	0.900Inches ± 0.030	0.930 0.870		
5	Strut Bracket	0.350Inches ± 0.010	0.360 0.340		
6	Strut Bracket	1.500Inches ± 0.030	1.530 1.470		
7	Strut Bracket	1.006Inches ± 0.030	1.036 0.976		
8	Strut Bracket	0.080Inches ± 0.010	0.090 0.070		

Plex 3/9/18 4:01 PM Dart.Gagnon.Michelle